

Work Order ID 85875

85875

Page 1

June-18-12 8:39:23 AM

Item ID: D205-634-011

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Skidtube

Start Date: 6/18/12 Start Qty: 1.00

1

Cust Item ID:

Required Date: 6/18/12 Req'd Qty: 1.00

1

Customer:

Reference: scrap

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
DSI9468	A
IIN D205-634	G

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Quality Control

Memo

INSPECT

D205-634-011 B80935

0.00

5/17/12

125

0.00

125

HandFinish

Hand Finishing

Memo

PULL FROM QRTN RACK

1 X D205-634-011 B80935

REMOVE AFT CAP AND ALL GASKETS AND WEARPLATES, CLEAN

AND RETURN TO STOCK UNDER ORIGINAL B/N:

1 X D2855 B75074

1 X D3566-13 B76947

1 X D3566-5 B80374

2 X D3566-1 B81619

1 X D3564-11 B75056

1 X D3564-13 B77610

1 X D3564-9 B76950

1 X D3564-5 B80343

0.00

1 0 12-6-12

Work Order ID 85875

85875

Page 2

June-18-12 8:39:23 AM

Item ID: D205-634-011 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Skidtube
Start Date: 6/18/12 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 6/18/12 Req'd Qty: 1.00 ***1*** Customer:
Reference: scrap

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
126		0.00							
126									
Skidtubes	Memo	0.00							
Skidtubes	SCRAP/DESTROY TUBE								
130		0.00							
130									
Packaging	Memo	0.00							
Packaging	RETURN K10003 B81665 TO STK								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

CF 12-6-18

12/6/21

12/6/22

MF 12-06-21

Picklist Print

June-18-12 8:39:23 AM

Page 1

Work Order ID: 85875

Parent Item: D205-634-011

Parent Item Name: Skidtube

Start Date: 6/18/12

Required Date: 6/18/12

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:P02.08.28Removed QC5 from Step 5KJ
 IPP Rev:Q 08-08-12 now @ chg 006 (DSI 9417) DD verf:EC
 IPP Rev R 09.01.28 now chg 007 DSI9417 revB EC verf:DD IPP Rev:S 10.12.01 as per chg008
 DD verf:EC IPP REV:T 12.01.23 AS PER ECN11-684 VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3564-11 Wearshoe		Manufactured	No				Each	26.0000		-1		BR 12-6-18	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				FG		4							
				77056 ✓		4							
				FP001		22							
				83910		22							
D3564-13 Wearshoe		Manufactured	No				Each	23.0000		-1		BR 12-6-18	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				FP001	77610.	1							
				71594		1							
				FP002		22							
				82249		22							
D3564-5 Wearshoe		Manufactured	No				Each	36.0000		-1		BR 12-6-18	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				FG	80343.	2							
				34806		2							
				FP001		34							
				77609		1							
				82254		8							
				84869		25							

AFTCAP

2855

B. 75074

BR 12-6-18

Picklist Print

June-18-12 8:39:23 AM

Page 2

Work Order ID: 85875
Parent Item: D205-634-011
Parent Item Name: Skidtube

Start Date: 6/18/12

Required Date: 6/18/12

Start Qty: 1.00

Required Qty: 1.00

D3564-9
Wearshoe

Manufactured No

Each 18.0000

-1

BR 126-18.

Location

Loc Qty

Loc Code

FG

4

76950 ✓

4

FP001

14

67590

4

69943

1

82255

9

D3566-1
Gasket

Manufactured No

Each 93.0000

-1

BR 126-18.

Location

Loc Qty

Loc Code

FP

-32

FP002

125

68924

2

80919

3

83898

16

84879

72

D3566-1
Gasket

Manufactured No

Each 93.0000

-2

BR 126-18.

Location

Loc Qty

Loc Code

FP

-32

FP002

125

68924

2

80919

3

83898

16

84879

72

June-18-12 8:39:23 AM

Shop Packet Print

Page 2

Picklist Print

June-18-12 8:39:23 AM

Page 3

Work Order ID: 85875
Parent Item: D205-634-011
Parent Item Name: Skidtube

Start Date: 6/18/12
Start Qty: 1.00

Required Date: 6/18/12
Required Qty: 1.00

D3566-13 Manufactured No Each 56.0000

-1 BR 126-18.

Gasket

Location	Loc Qty	Loc Code
FP	10	
83351	10	
FP002	46	
76947 ✓	1	
84880	45	

SCRAP

D3566-5 Manufactured No Each 52.0000

-1 BR 126-18.

Gasket

Location	Loc Qty	Loc Code
FP	10	
82275	10	
FP002	42	
80374 ✓	3	
82274	6	
84881	33	

SCRAP

K10003 Manufactured No Each 6.0000

-1 B81665 Comp 6/22

Saddle, D205-634-011

Location	Loc Qty	Loc Code
PKG	6	
57963	0	
81667	2	
82164	4	

Linda Lacelle

From: Eric Downing <edowning@dartaero.com>
Sent: June-17-12 8:27 AM
To: 'L Lacelle'; Melanie Fauteux
Cc: psmith@dartaero.com
Subject: RE: D205-634-011

Linda /Mel could you please create me a work order to do the following

Pull from stock D205-634-011 B80935

Remove all wear plates and gaskets, clean and return to stock under original Batch #

Remove aft cap, clean and return to stock under original Batch #

Return K kit and return to stock under original Batch #

Scrap and Destroy Skid Tube due to holes not drilled correctly

Thanks

Eric Downing

85875

From: David Shepherd [mailto:dshepherd@dartaero.com]
Sent: Saturday, June 16, 2012 12:03 AM
To: 'Eric Downing'; psmith@dartaero.com; 'Bill Beckett'
Cc: 'L Lacelle'; 'Provencal, Chris'; 'Eric Charbonneau'; 'Jean-Luc Menard'
Subject: RE: D205-634-011

Eric,

Agreed ... Unfortunately, I believe we should salvage the wearplates and aft cap and scrap the rest of the skidtube.

David

From: Eric Downing [mailto:edowning@dartaero.com]
Sent: June-14-12 9:54 AM
To: David Shepherd; psmith@dartaero.com; 'Bill Beckett'
Cc: 'L Lacelle'; 'Provencal, Chris'; Eric Charbonneau; Jean-Luc Menard
Subject: D205-634-011

David this is about the D205-634-011 B80935 that is sitting on the Quarantine rack. The holes were not drilled correctly and now the saddles will not align correctly. The tube is swaged and we have discuses in the past and today there is no way to salvage this tube.

My opinion and I believe it is yours as well is to scrap this tube and save the wear plates, aft cap and return the kit back into stock.

Do you agree??

We have been using better inspection tooling before the tube is swaged and if its found to be off we (Dan and his Team) swage in cross bolt spacer before bending to do a correct test fit before any more time and money is put in to it. I have talked with Pat about this in the past and I think almost every day and I do believe we are in need of better tooling for fabricating the skid tubes in landing gear and better tooling for inspecting during in progress and at final inspection.

Thanks

Work Order ID 80935***809.35***

Page 1

Monday, March 05, 2012 1:26:00 PM

Item ID: D205-634-011

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Skidtube

Start Date: 3/5/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 3/21/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: Date: 2-23-5

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
DSI9468	A								
IIN D205-634	G								

100

0.00

100

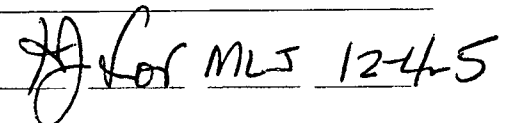
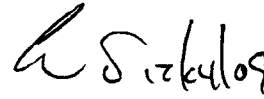
DC

Document Control

Memo

Photocopy bluefile & type to
CHG 010

D205-634-011

 For MLS 12-4-5

110

Pick Kit

110

Packaging

Packaging

Memo

0.00

**B78827**

Work Order ID 80935***80935***

Page 2

Monday, March 05, 2012 1:26:01 PM

Item ID: D205-634-011

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Skidtube

Start Date: 3/5/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 3/21/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Run Start ***NR1***

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Sizley

XL

Quality Control

130

0.00

130

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D205-634-011

Location: _____

PPP rev: _____

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

12/4/10

12/4/10

R12-04-10

Picklist Print

Page 1

Monday, March 05, 2012 1:26:06 PM

Work Order ID: 80935

80935

Parent Item: D205-634-011

D205-634-011

Parent Item Name: Skidtube

Start Date: 3/5/2012

Required Date: 3/21/2012

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:P02.08.28Removed QC5 from Step 5KJ

IPP Rev:Q 08-08-12 now @ chg 006 (DSI 9417) DD verf:EC

IPP Rev R 09.01.28 now chg 007 DSI9417 revB EC verf:DD IPP Rev:S

10.12.01 as per chg008 DD verf:EC

IPP REV:T 12.01.23

AS PER ECN11-684 VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D205-634-041		Manufactured	No			110	Each	1.0000	1	1			
S *D205-634-041*													
Replacement Skidtube													

Location

Loc Qty

Loc Code

FG073

1

K10003

4117010

Manufactured No

110

Each

0.0000

1

1

**

S *K10003*

Saddle, D205-634-011

81865 R 12/12

81665

Picklist Print

January-16-12 1:06:01 PM

Page 1

Work Order ID: 78827

78827

Parent Item: D205-634-041

D205-634-041

Parent Item Name: Replacement Skidtube

Start Date: 16/01/2012

Required Date: 30/01/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30
KJ IPP Rev P 10.02.19
per PAR09-043 EC verified by:DD
IPP Rev: O 06.02.28 Added paperwork EC
IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM IPP Rev:Q
10.12.01 as per chg003 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4202-1 *D4202-1* Spacer		Manufactured	No			140	Each	446.0000	20	20			
									**			12-03-16	
				<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>							
				LG	446								
				77727	123								
				77729	323								
D2580-1 *D2580-1* 205 Skidtube bent detail		Manufactured	No			110	Each	9.0000	1	1			
									**			12/03/14	
				<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>							
				LG	9								
				76570	2								
				77679	2								
				78240	2								
				78241	1								
				78531	2								
D2576-3 *D2576-3* Step (maching detail)		Manufactured	No			140	Each	86.0000	1	1			
									**			12/03/14	
				<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>							
				LG	86								
				70883	36								
				74136	50								

Picklist Print

Page 2

January-16-12 1:06:01 PM

Work Order ID: 78827

78827

Parent Item: D205-634-041

D205-634-041

Parent Item Name: Replacement Skidtube

Start Date: 16/01/2012

Required Date: 30/01/2012

Start Qty: 1.00

Required Qty: 1.00

D2855

Manufactured No

200

Each

33.0000

1

1

D2855

Cap

**

B75074 (x1) ML 12/03/27

Location

Loc Qty

Loc Code

FP002

33

65519

2

73347

31

AN3-5A

Purchased

No

200

Each

1,262.000

2

2

AN3-5A

Bolt

**

ML 12/03/27

Location

Loc Qty

Loc Code

ST350

1262

115371

46

117423

216

118626

300

119355

200

120187

500

AN960JD10L

NAS1149D0332J

Purchased

No

200

Each

0.0000

2

2

*AN960JD10L *✓

Washer

**

M120644 (x2) ML 12/03/27

January-16-12 1:06:01 PM

Shop Packet Print

Page 2

Picklist Print

Page 3

January-16-12 1:06:01 PM

Work Order ID: 78827

78827

Parent Item: D205-634-041

D205-634-041

Parent Item Name: Replacement Skidtube

Start Date: 16/01/2012

Required Date: 30/01/2012

Start Qty: 1.00

Required Qty: 1.00

ALS7-1032-130

Purchased

No

200

Each

2,472.000

50

50

**

912 12/03/27

AI S7-1032-130

Insert

Location

Loc Qty

Loc Code

ST280

328

117717

27

118966

22

119775

279

ST281

71

119794

71

ST282

2073

119530

73

120181

2000

X50

AN3C4A

Purchased

No

200

Each

2,992.000

50

50

**

11120521 X50 912 12/03/27

AN3C4A

BOLT

Location

Loc Qty

Loc Code

ST350

2992

117313

2

117688

5

117872

10

118112

16

118451

2

118838

13

119749

944

120187

2000

AN960C10L

NAS1149C0332

Purchased

No

200

Each

0.0000

50

50

**

11120648 X50 912 12/03/27

*AN960C10I *

washer

January-16-12 1:06:01 PM

Shop Packet Print

Page 3

Picklist Print

Page 4

January-16-12 1:06:01 PM

Work Order ID: 78827

78827

Parent Item: D205-634-041

D205-634-041

Parent Item Name: Replacement Skidtube

Start Date: 16/01/2012

Required Date: 30/01/2012

Start Qty: 1.00

Required Qty: 1.00

D3566-13

Manufactured No

200 Each

64.0000

1

1

D3566-13

**

Gasket

LocationLoc QtyLoc Code

FP002

64

68341

1

73322

3

76947

60

D3566-5

Manufactured No

200 Each

37.0000

1

1

D3566-5

**

Gasket

LocationLoc QtyLoc Code

FP002

37

75069

4

76945

33

D3566-1

Manufactured No

200 Each

20.0000

2

2

D3566-1

**

Gasket

LocationLoc QtyLoc Code

FP002

20

68924

2

76942

18

D3564-11

Manufactured No

200 Each

7.0000

1

1

D3564-11

**

Wearshoe

LocationLoc QtyLoc Code

FP001

7

77614

7

January-16-12 1:06:01 PM

Shop Packet Print

Page 4

Picklist Print

Page 5

January-16-12 1:06:01 PM

Work Order ID: 78827

78827

Parent Item: D205-634-041

D205-634-041

Parent Item Name: Replacement Skidtube

Start Date: 16/01/2012

Required Date: 30/01/2012

Start Qty: 1.00

Required Qty: 1.00

D3564-13

Manufactured No

200

Each

49.0000

1

1

D3564-13

Wearshoe

**

yl 12/03/27

Location

Loc Qty

Loc Code

FP001

28

71594

1

75045

12

77610

15

FP002

21

76946

21

yl

D3564-9

Manufactured No

200

Each

6.0000

1

1

D3564-9

Wearshoe

**

1376950 (x1) yl 12/03/27

Location

Loc Qty

Loc Code

FP001

6

67590

4

69943

1

75071

1

D3564-5

Manufactured No

200

Each

48.0000

1

1

D3564-5

Wearshoe

**

1380343 (x1) yl 12/03/27

Location

Loc Qty

Loc Code

FG

2

34806

2

FP001

46

73330

1

76269

18

76944

15

77609

12

January-16-12 1:06:01 PM

Shop Packet Print

Page 5

Picklist Print

Page 6

January-16-12 1:06:01 PM

Work Order ID: 78827

78827

Parent Item: D205-634-041

D205-634-041

Parent Item Name: Replacement Skidtube

Start Date: 16/01/2012

Required Date: 30/01/2012

Start Qty: 1.00

Required Qty: 1.00

D2594-3

Manufactured No

200

Each

336.0000

16

16

D2594-3

O-Ring, 205 Skidtube

B76755 1x16 16 11/03/12

LocationLoc QtyLoc Code

FP001

336

65518

41

73490

295

D2594-1

Manufactured No

200

Each

352.0000

16

16

D2594-1

Plug, 205 Skidtube

16 11/03/12

LocationLoc QtyLoc Code

FP001

352

73401

30

74442

34

74869

184

76075

104

B77035

x 8
x 8

January-16-12 1:06:01 PM

Shop Packet Print

Page 6